


GARANT Master Alu solid carbide milling cutter HPC, DLC, Ø DC: 8mm

Order data

Order number	202512 8
GTIN	4062406238872
Item class	11X

Description
Version:
Extra sharp cutting edges.

Dimensions similar to DIN6527.

For roughing and finishing. Up to $2 \times D$ into solid material at very high feed rates and smooth cutting action.

With the latest generation of **DLC coating sp^2** .

Note:

Successor product to No. 202515.

Technical description

Overhang length L_1 incl. recess	27 mm
Shank Ø D_s	8 mm
No. of teeth Z	4
Flute length L_c	22 mm
Feed f_z for side milling in short-chipping aluminium	0.1 mm
Tolerance nominal Ø	h6
Cutting edge Ø D_c	8 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	63 mm
Helix angle	38 degrees

Data sheet

Feed f_z for slot milling in short-chipping aluminium	0.08 mm
Shank	DIN 6535 HA to h6
Recess $\varnothing D_1$	7.4 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.25 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N

Data sheet

PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/202512-8>